

ADDITIONAL INSTRUCTIONS FOR MOLD REPAIR

..... DO NOTHING BUT WORK CHECKED ON THIS MEMORANDUM WITH UNDERSTANDING THAT MONOTYPE CO. GUARANTEE APPLIES ONLY TO ITEMS CHECKED.

..... DO ANY ADDITIONAL WORK MONOTYPE CO. DETERMINES NECESSARY TO GUARANTEE SATISFACTORY MOLD OPERATION ON ANY MONOTYPE COMPOSITION CASTING MACHINE OR TYPE-&-RULE CASTER IN PROPER OPERATING CONDITION.

REMARKS

Name of Firm.....

Date..... Signed

(See "Mold Repairs" on page 4)

SAVE THIS FOLDER. SEE PAGE 5

**IMPORTANT INFORMATION
FOR OPERATORS OF
Monotype Molds**

When Returning Molds Use Page Five



MOLD FOLDERS

If you do not have a folder giving directions for care and cleaning your Molds write for the ones you require. We carry them for the following:

COMPOSITION MOLDS, STYLE 1E

COMPOSITION MOLDS, STYLE 2E

COMPOSITION MOLDS, STYLE 3E

SORTS CASTING MOLDS, STYLES 1T and 1U
(Also used for Styles 2T, 2U, 3U and 4U)

CORED SORTS CASTING MOLDS, STYLE 3U
AND OPERATING ATTACHMENT

SORTS CASTING MOLDS, STYLES Y and Z

LEAD-&-RULE MOLDS, STYLES 1R, 1RA and 1RB
(Also used for Styles 2R, 2RA and 2RB)

SHORT TYPE MOLDS, STYLES 2FC and FD
(Also used for Style FC)

NOTE: For Giant Caster and Material Making Machine Molds see book of Adjustments for each machine.



**LANSTON MONOTYPE MACHINE COMPANY
PHILADELPHIA 3, PA.**

**CHECKING MOLDS and
MAIN STANDS**

All Monotype Molds, both new and repaired, are guaranteed to be in good operating condition when they leave our factory. They should be tested promptly upon receipt by the customer and if there is any complaint it should be made to the Monotype Co., Philadelphia, immediately.

The printed instructions (see list on page 1) should be followed for the care, maintenance, and operation of Molds. Proper oil, in correct quantities, is essential for satisfactory Mold operation. On page 3 is a list of oils which long experience has proven to be satisfactory for each type of Mold as indicated. We are prepared to supply these oils to our customers.

The machines on which we test Molds are checked frequently, not only for adjustments, but also for wear—and particularly wear of the Main Stand where the Mold is fastened on Composition Casting Machines and Type-&-Rule Casters. In customers' plants this seat on the Main Stand will, in time, become worn or damaged by changing Molds, or rusted around the waterways, or possibly warped slightly by the heat of casting. A Mold placed on such a machine will not have a true bearing for the three feet, and when the three Mold Screws are tightened, the Base Plate of the Mold will be distorted, and some or all of the Blocks on the Mold will be thrown out of proper relation one with another. If a Mold is run under such conditions, it may result in wear or damage to the parts of the Mold and also in the casting of unsatisfactory product.

If a Mold does not operate satisfactorily, do not blame the Mold until its seat on the Main Stand has been checked. Each Monotype District Office is supplied with a special Gage for this purpose. Get in touch with them. Sometimes the Main Stand can be corrected in the customer's plant. If badly worn, it may have to be returned to our factory for regrinding. On very old machines this condition, plus wear, may make it advisable to exchange the machine.

3735

PREPARING NEW OR REPAIRED MOLDS FOR CASTING

To protect Molds from rust during shipment we are at present using a light refined grade of grease which forms a very thin film on the Mold, but gives perfect protection. Unless such Molds have remained in stock for a considerable period of time it is not necessary to use any kind of cleaning fluid for removing this grease. It is sufficient to remove the Cross Block, wipe the grease from it with a dry cloth and from the rest of the Mold including the channel in which the Cross Block operates and then thoroughly oil all parts of the Mold. If gasoline, benzine or any other cleaning fluid is used for removing the grease it will de-grease any oil pads and prevent oil getting through them for a considerable period of time unless the oil pads are first removed and then replaced after the cleaning is completed.

LUBRICATING OILS

Casting Machine Oil—For the general lubrication of all Casting Machine parts and for all Molds which cast *type* except Giant Caster Molds and Style 3U and 4U Cored Molds.

Rule Mold Oil—For exclusive use on all Giant Caster Molds and all Material Making Machine Molds; also on Style 3U and 4U Cored Type Molds and all Lead-&-Rule Molds.

Keyboard Oil—A special light-bodied oil for the lubrication of all parts on Monotype Keyboards requiring lubrication.

CAUTION: Not only the quality of the product, but the very life of Monotype Molds and Monotype Machines depends on the use of the correct oil for each purpose. We have spared neither time nor trouble in finding the best and in maintaining a high standard of each kind. The oil that we recommend and sell as "Rule Mold Oil" is especially essential for the satisfactory operation and preservation of all Material Making Machine Molds and Giant Caster Molds, also 3U and 4U Cored Molds and all Lead-&-Rule Molds. We cannot guarantee these Molds to operate satisfactorily if any other oil is used.

WATER REGULATION

To prevent water leaks in Molds and produce the best quality of product on Composition Casting Machines and Type-&-Rule Casters regulate the water as follows: Open wide the valve on the drain pipe. Slowly open the valve on the supply pipe until the water flows with a full stream from the drain pipe having the valve, but none from the other drain pipe. Note how many turns or what part of a turn the supply valve is opened and open it this amount each time the water is to be turned on. Next, partly close the valve in the drain pipe so that a portion of the stream of water is forced up through the Mold and comes out the other drain pipe. The amount of water to be thus by-passed through the Mold is determined by the temperature of the water coming out of this drain pipe from the Mold. This water should be approximately 130 degrees in temperature. The bulb of a thermometer placed in this stream of water will give the temperature accurately. If no thermometer is available, stick the finger in the stream of water which should be so hot that the finger cannot be held in it.

NOTE: Old machines not equipped with globe type valves require slight modification of above directions.

MOLD REPAIRS

Gate Pushers, Vent Pushers, and Caps for low leads and slugs can usually be furnished without returning the Mold if all pieces of the broken part are sent to us—for new Cap send also its Support. Packing Pieces for Rule Molds are furnished from stock.

It is not possible for operators to repair Molds because they have neither the special tools nor the necessary training.

If any defects occur in the type produced by this Mold, that cannot be corrected by following the directions in our Mold Folders, the Mold should be at once returned to us with samples of defective type; enclose these in the box with the Mold (*also all extra Blades, Point Blocks, Mold-blade Stops and Caps and Supports*), prepay transportation charges and write us stating (a) the style, point size, and number of Mold; (b) date of shipment and route; (c) **IMPORTANT**, on page 5 of this folder is a list of the more common troubles due principally to wear. **MARK an X** before each item of the list which gives trouble, as we will check and test Molds particularly for the troubles marked.

**Preserve Mold Box and Screws for returning Mold.
Do not nail the cover — tie it on.**

ATTENTION OPERATORS

To insure getting the repairs you want tear off this page, check items needing correction and send it to the Monotype Co., Philadelphia, by First Class Mail (never with the mold unless the mold is sent by Express).

For all TYPE Molds

As Used on Composition Casting Machines and Type-&-Rule Casters

Point	Style	Serial No.
-------	-------	------------

- **Have you enclosed type samples?**
- Mold casting type too low (restore height).
- Type burring on feet.
- Type burring on cross block side.
- Type not parallel (setways) . . . large at top
- Type not parallel (setways) . . . large at bottom.
- Type not parallel (pointways) . . large at top
- Type not parallel (pointways) . . large at bottom.
- Top mold blade out of relation with bottom blade, in casting position.
- Corner of large (right) type block damaged.
- Corner of small (left) type block damaged.
- Water ways stopped up.
- Water leak (specify where).
- Undercutting caused by worn latch
- worn fork low quad adjustment.
- Nick pin worn (metal leaks through).
- Nick pin damaged on front end.
- Cross block cut.
- Type block cut . . . large (right) . . . small (left).
- Gate pusher leading.
- Mold blade hangs up . . . sizing . . . ejecting.

REMARKS: Any trouble not covered by above list, specify details on back of this sheet. Unless otherwise instructed we make all repairs required to put the Mold in good operating condition, including restoring to height if our inspection indicates it would finish to cast type below our low limit of .9168 (high quad minimum of .8868" on composition molds or .8668" on display molds).